

Date: Tuesday, 7/1/2008 2:33:14 PM  
 User: Kim Johnston

## Process Sheet

31

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/212/130 BASKET LID  
 Job Number : 40180A  
 Estimate Number : 10193  
 P.O. Number :  
 This Issue : 7/1/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2512  
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2512 UNDER REVIEW  
 Previous Run : 40005B Drawing Revision : D2  
 Material :  
 Due Date : 7/30/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : 08.07.01  
 Comment : Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/RF  
 Est Rev:N 06.04.05 Added level21 EC

## Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: 71108250

SAN

08/07/08

①

2.0 D31663 Basket Hoop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3166-3 Basket Hoop

B38780

SAN

08/07/08

①

3.0 D2506 Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2506 Label Plate

B37446

CPL

08.07.16

4.0 D23271 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2327-1 Bushing

B340084

CPL

08.07.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:33:14 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 40180A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 D2232-1 Hinge plate

Batch

339454

*Pl 08-07-16*

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 D2581 Mounting Bracket

Batch

B39046

*Pl 08-07-16*

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description  
18 sf M304EX0.75-16F Expanded Metal

Batch

M108474

*Pl 08-07-16*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

*34N 08/07/08*

①

*Pl 08-07-16*

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 08-07-16*

①

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*068/7/16*

①

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Drawing Name: 350/212/130 BASKET LID

Job Number: 40180A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

POWDER COATING



M 107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT 2ND COAT  
START TIME: 1:30 pm START 2:00 pm  
OVEN TEMPERATURE: 400°F TEMP 400°F  
FINISH TIME: 2:00 pm Finish 2:30 pm

08-07-17 (X1)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



SPRAY PAINT M108593



M/L 08/07/18  
M108496 (1X)

Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch:

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-07-18 (1)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6-A

08/07/21 (1)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/22 (1)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

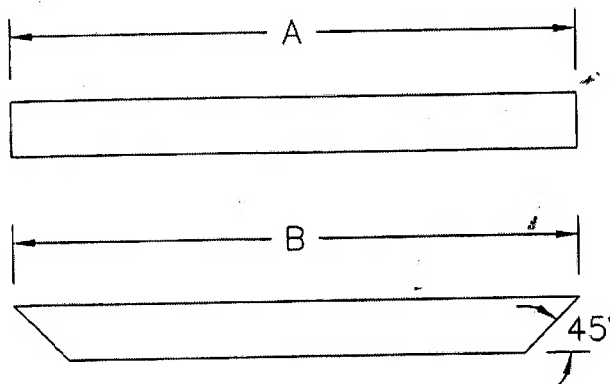


DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. 0 SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212)	SCALE NTS
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074	
D	01.04.19	CHANGE HINGE	
D1	# UP 03.01.20	ADD D2012-117 FOR D130-701-041	
D2	# UP 04.07.20	TACK WELD ANT-SKID AREA	

RELEASED  
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



UP 08.07.01  
**UNDER REVIEW**  
08.02.05 #

TUBING TO BE  
CHANGED TO 0.065  
WALL

SHOP COPY  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40180A

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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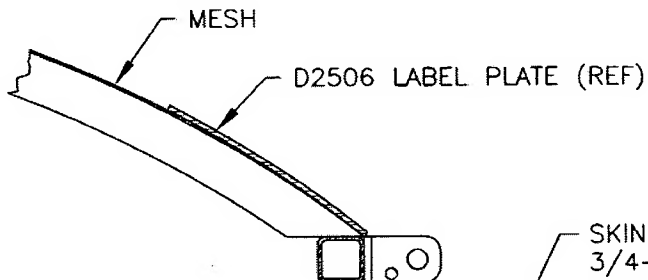
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CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D2512
DATE	TITLE	REV. D
01.04.19	BASKET LID ASSEMBLY (350/212)	SHEET 2 OF 4
		SCALE 1:20

UNDER REVIEW  
08.02.06 PW  
TUBING TO BE  
CHANGED TO 0.625  
WALL

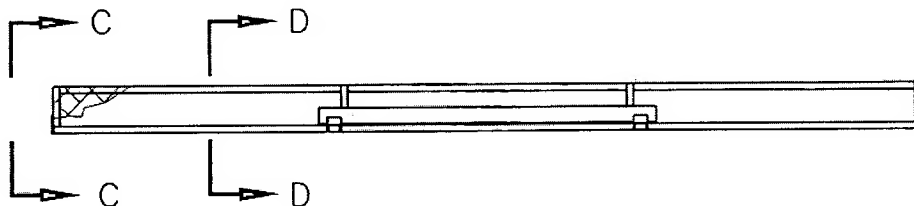
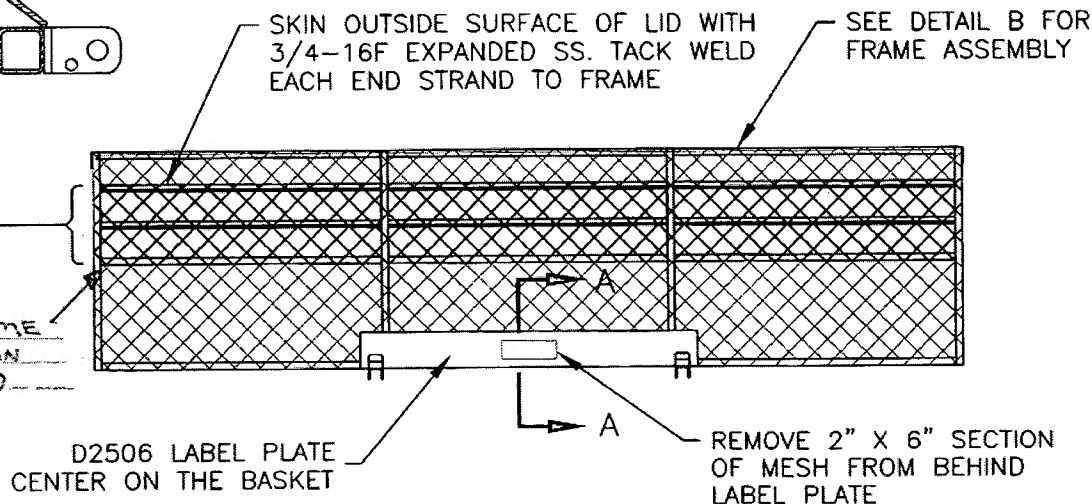
*[Handwritten signature]*



SECTION A-A  
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG  
ENTIRE LENGTH PER NOTE 3  
AFTER POWDER COAT.

*[D2 stamp]* TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED



**D2512 BASKET LID ASSEMBLY**

MESH MATERIAL: 3/4-16F EXPANDED SS

FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3

SPRAY PAINT BLACK INSIDE SURFACE

APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

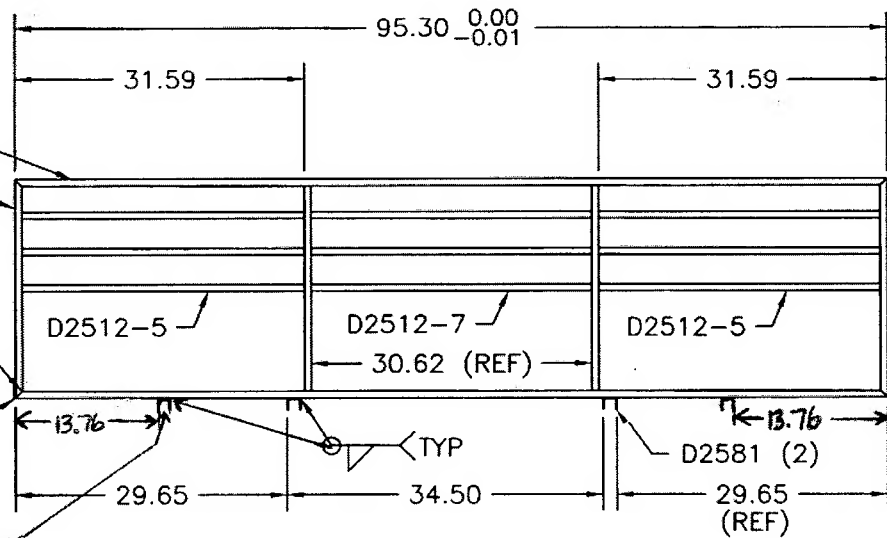
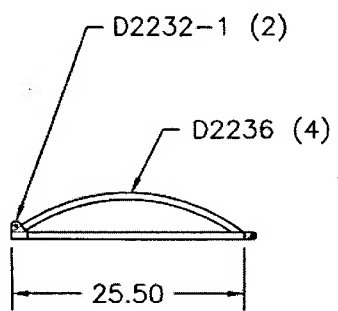
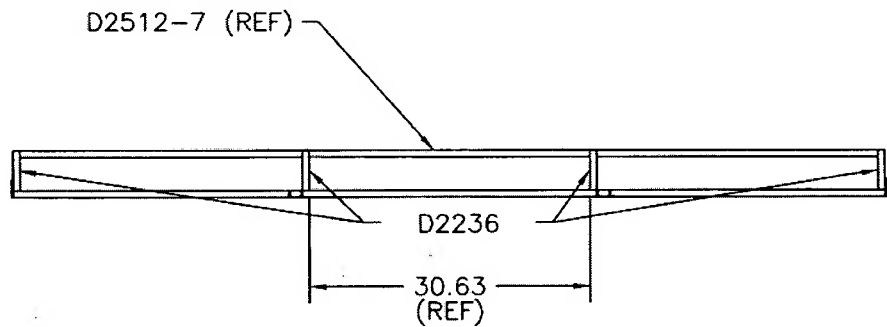
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40180A





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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2512
DATE	01.04.19	TITLE	BASKET LID ASSEMBLY (350/212)	REV. D SHEET 3 OF 4 SCALE 1:20



UNDER REVIEW  
08.04.05  
TUBING TO BE  
CHANGED TO 0.065  
WALL

RELEASED  
01.01.27

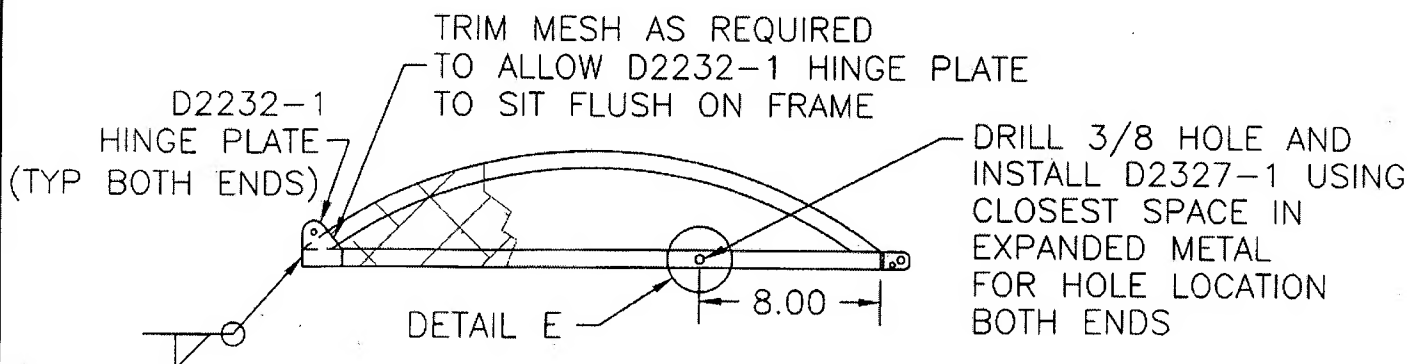
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4018074

D2012-117 CLEVIS  
ADD FOR D130-701-041  
ONLY (2 PLACES)

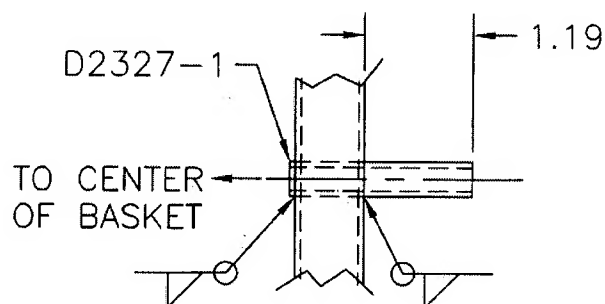
DETAIL B  
FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES



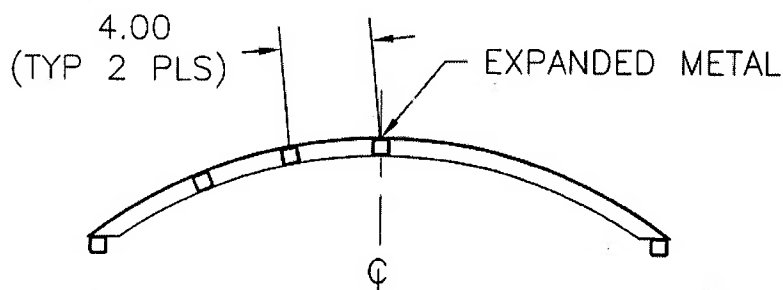
DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE 1:8



SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

SHOP COPY  
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WORK ORDER  
40180A  
08.07.01  
08.02.01  
TUBING TO BE  
CHANGED TO 0.065  
WALL

**RELEASED**  
01.04.27

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